

Work Order ID 105455

August-06-13 11:02:48 AM

105455

Page 1

Item ID: D2057

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Plug

Stop

NS2

Start Date: 8/06/13 Start Qty: 40.00

40

Required Date: 8/20/13 Req'd Qty: 40.00

40

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: MUS

Date: 13/08/06

Tooling:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100	Hardinge CNC LATHE SMALL.								
Hardinge	Memo	0.00	DAS						
Hardinge CNC Lathe Small	Make as per Dwg D2057 and Folio FA260.		40						
	Break all sharp edges 0.015 max.		9-89						
	Do not drill Ø0.191			DAS					
			44						
			9-89						
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00	DAS						
Quality Control			40						
			9-89						
				DAS					
			44						
			9-89						
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00	SD						
Quality Control			13-8-8						

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	<input type="checkbox"/> Bend			Grain	<input type="checkbox"/> Ovalized			<input type="checkbox"/> Pressure/Forced			
Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route			Hardware	<input type="checkbox"/> Over/Under tolerance			<input type="checkbox"/> Temperature/Cure			
Cracks	<input type="checkbox"/> Broken/Damaged			Inspection Incomplete	<input type="checkbox"/> Part Incorrect			<input type="checkbox"/> Weld			
Crushed/Crimped	<input type="checkbox"/> Burrs			Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing			<input type="checkbox"/> Wrong Stock Pulled			
Cuffs	<input type="checkbox"/> Contamination			Maintenance	<input type="checkbox"/> Part Moved			<input type="checkbox"/> Other			
Heat Treat	<input type="checkbox"/> Countersink			Mislabeled	<input type="checkbox"/> Positioned Wrong			<input type="checkbox"/> Power Loss/Surge			
Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short			Misread	<input type="checkbox"/> Offset			<input type="checkbox"/> Other			
Ripples in Bend	<input type="checkbox"/> Drill Holes			Offset	<input type="checkbox"/> Out of Calibration			<input type="checkbox"/> Other			
Torque Waves in Extrusion	<input type="checkbox"/> Drawing			Out of Calibration	<input type="checkbox"/> Out of Sequence			<input type="checkbox"/> Other			
Turning Sequence	<input type="checkbox"/> Finish			Out of Sequence	<input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Other			
Wave/Twist in Tube	<input type="checkbox"/> Folio			Outside Dimensions							

Work Order ID 105455

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105455

Page 2

Item ID: D2057

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Plug

Stop

NS2

Start Date: 8/06/13 Start Qty: 40.00

40

Required Date: 8/20/13 Req'd Qty: 40.00

40

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date: Tooling:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept

Reject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 51005

0.00

130

Packaging

Memo

0.00

40X M.D. 13-08-8

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

MJ 13-08-08MJ 13-08-08

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. _____	Work Order Update <input type="checkbox"/>						

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced
Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure
Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld
Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled
Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Part Moved	
Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Positioned Wrong	
Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other
Ripples in Bend	<input type="checkbox"/> Drill Holes		
Torque Waves in Extrusion	<input type="checkbox"/> Drawing		
Turning Sequence	<input type="checkbox"/> Finish		
Wave/Twist in Tube	<input type="checkbox"/> Folio		

WORK ORDER

August-06-13 11:02:51 AM

Work Order ID: 105455

105455

Parent Item: D2057

D2057

Parent Item Name: Plug

Start Date: 8/06/13

Required Date: 8/20/13

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP ID02.08.22 Make in CobraKJ
IPP Rev:E 08-05-27 as per ECN1195P DD verified by:EC
IPP Rev:F 08-06-04 Added QC8 JLM Verified By:EC
IPP Rev:G 08-06-20 rev.D as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	52.2610	0.1	4.210526			**

M6061T6R0 750

6061-T6 Round Bar .750"

Location	Loc Qty	Loc Code
MAT	52.261	
→ 125552	52.261	

21.22 ft DAS
44 8-89 13/08/08

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
				Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	General			Grain				Ovalized	Pressure/Forced		
Centre Not Concentric to O/S				Hardware				Over/Under tolerance	Temperature/Cure		
Cracks				Inspection Incomplete				Part Incorrect	Weld		
Crushed/Crimped				Instructions Incomplete/Unclear				Part Lost/Missing	Wrong Stock Pulled		
Cuffs				Maintenance				Part Moved			
Heat Treat				Mislabeled				Positioned Wrong			
Inspection Strip in Tube				Misread				Power Loss/Surge			
Ripples in Bend				Offset							
Torque Waves in Extrusion				Out of Calibration							
Turning Sequence				Out of Sequence							
Wave/Twist in Tube				Outside Dimensions							

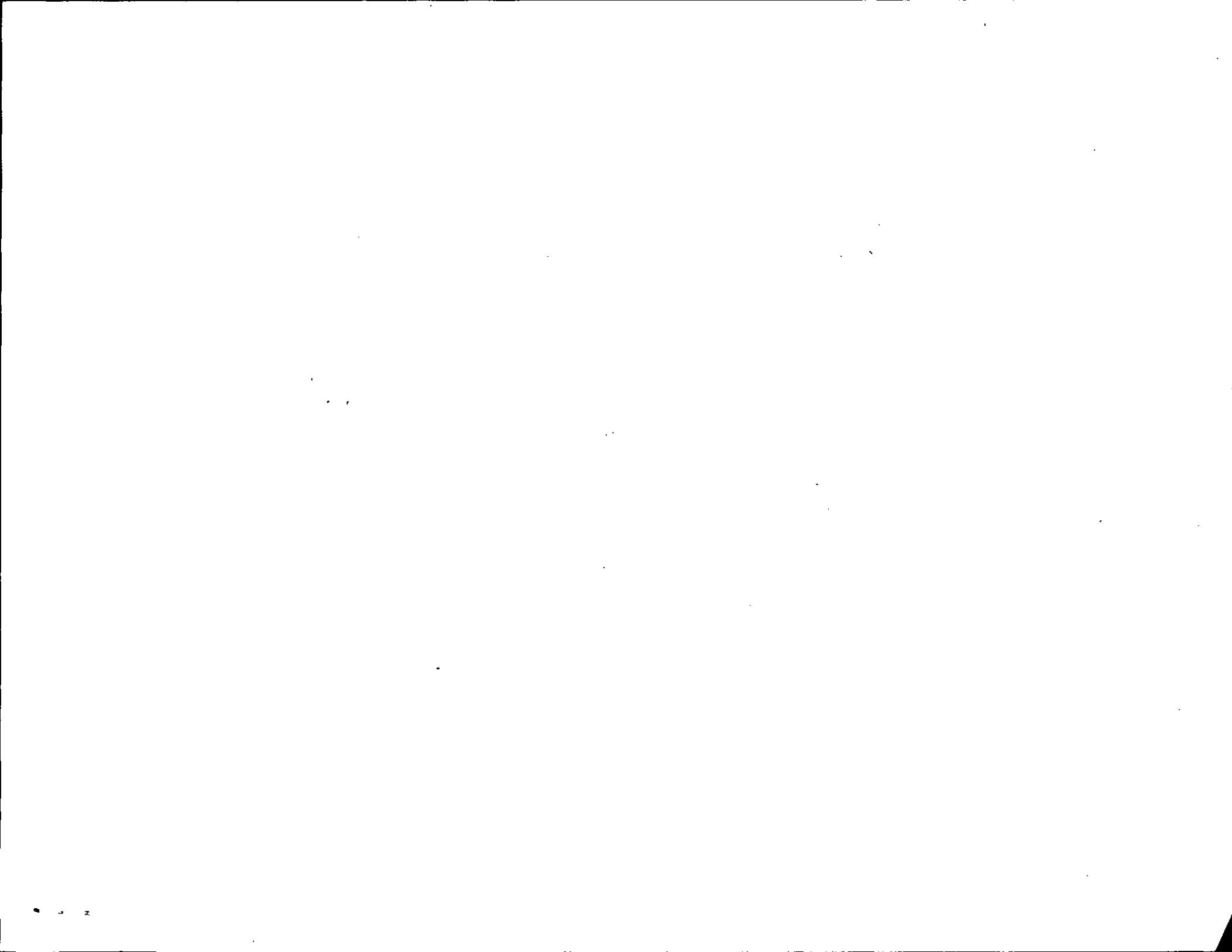
DART AEROSPACE LTD	Work Order:	105455
Description: Plug	Part Number:	D2057
Inspection Dwg: D2057	Rev: C	Page 1 of 1

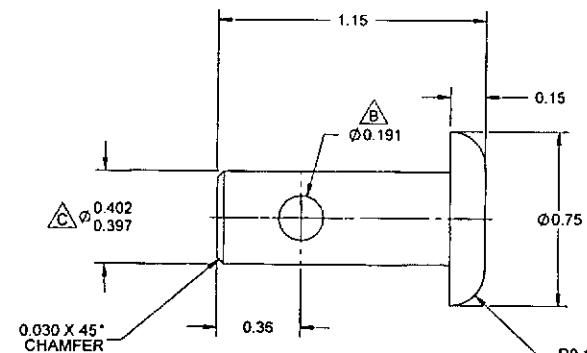
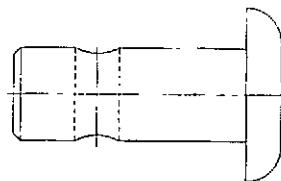
FIRST ARTICLE INSPECTION CHECKLIST

OAS OAS

Measured by:	40 9-83	Audited by:	5	Preliminary Approval:	.
Date:	13/08/07	Date:	13-8-07	Date:	

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	07.11.26	Dimensions added	KJ/EC/DD	
C	08.07.03	0.397-0.402 dimension revised	KJ/DD	
D	12.10.16	Dimensions revised	KJ	MM

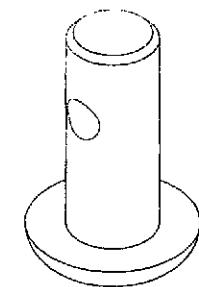




D2057 PLUG

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs



105455 MLJ
13-08-06

RELEASED
08.06.10

C	Ø0.402/Ø0.397 WAS Ø0.430/Ø0.425; REASON: ID OF D2010-103-104 DECREASED TO Ø0.402	PH	08.06.10
B	REDRAWN, Ø0.191 WAS Ø0.187 (TSR A1100)	CP	98.10.15
A	NEW ISSUE	JB	92.03.13
REV.	DESCRIPTION		
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	104	HAWKESBURY, ONTARIO, CANADA	
CHECKED	15	DRAWING NO.	REV. C
MFG. APPR.	102	D2057	SHEET 1 OF 1
APPROVED	102	TITLE	SCALE
DE APPR.	102	PLUG	NTS
DATE	08.06.10	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

